

Date: Monday, 12/01/2009 2:29:49 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 44550	
Estimate Number : 10618	
P.O. Number :	Part Number : D265637
This Issue : 12/01/2009 S.O. No. :	Drawing Number : D2656 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 44159	Material :
Written By :	Due Date : 30/01/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 09.01.12</u>	
Comment : Est Rev: D 02.10.25 Re-format KJ Est Rev: E 06-06-12 Now on Waterjet JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025 SHEET
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Comment: Qty.: 0.5650 sf(s)/Unit Total: 5.6501 sf(s)
 1010/1025 .040" SHEET
 (M1010S20GA)
 Batch: 110368 1B 9-2-2

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2656
 Dwg Rev: D
 Prog Rev: D 1B 9-2-2

⑬

2-Deburr if necessary 1B 9-2-2

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5 09/02/02 (13)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary. N/A S

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:29:49 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 44550

Part Number: D265637

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326.

2- Identify as D2656-37

SB 09/02/03 (13)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/03 (X13)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

13:20

OVEN TEMPERATURE:

320°

FINISH TIME:

13:50

FL

09-02-03 (13)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-03

(13)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-20

FL

09/02/03

(13)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/04

Job Completion



W 09.02.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>W4550</u>
Description: Wearshoe		Part Number: D2656-37
Inspection Dwg: D2656	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300 x 0.300	+/-0.010	300 x 300	x			
1.885	+/-0.010	1.889	x			
2.000	+/-0.010	2.000	x			
4.750	+/-0.010	4.750	x			
9.500	+/-0.010	9.500	x			
14.250	+/-0.010	14.250	x			
17.750	+/-0.010	17.750	x			
22.500	+/-0.010	22.500	x			
27.250	+/-0.010	27.250	x			
30.750	+/-0.010	30.750	x			
0.040	+/-0.010	.036	x			

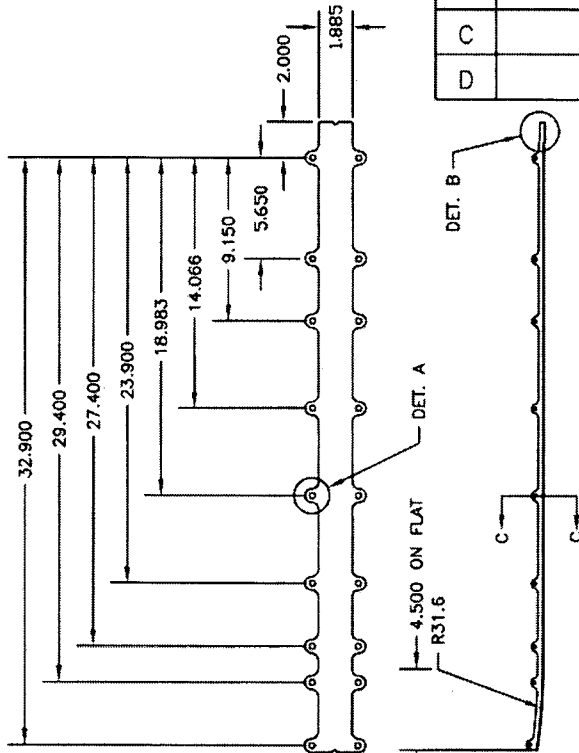
Measured by: <u>HB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>9-2-2</u>	Date: <u>09/02/12</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.07	New Issue	KJ/JLM	
B	08.11.27	Dimensions updated per Dwg Rev. D	KJ/EC	<u>HB</u>

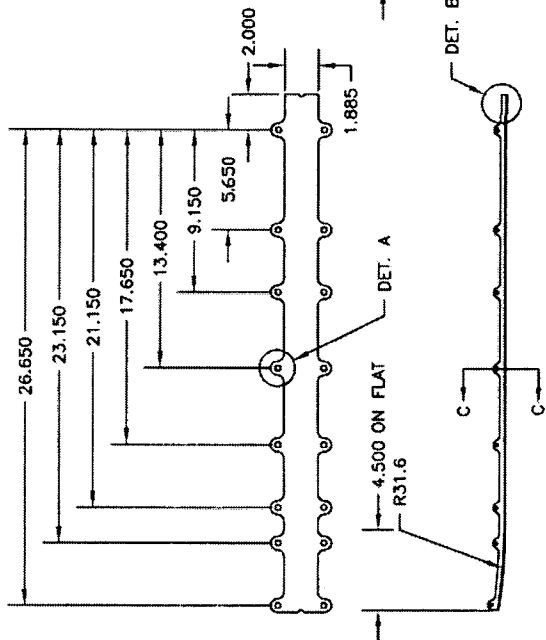


DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2656	REV. D SHEET 1 OF 4
DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10
A	97:03:25	NEW ISSUE	
B	97:06:02	CHANGED TABS	
C	97:06:26	R31.6 WAS R19.5	
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT	

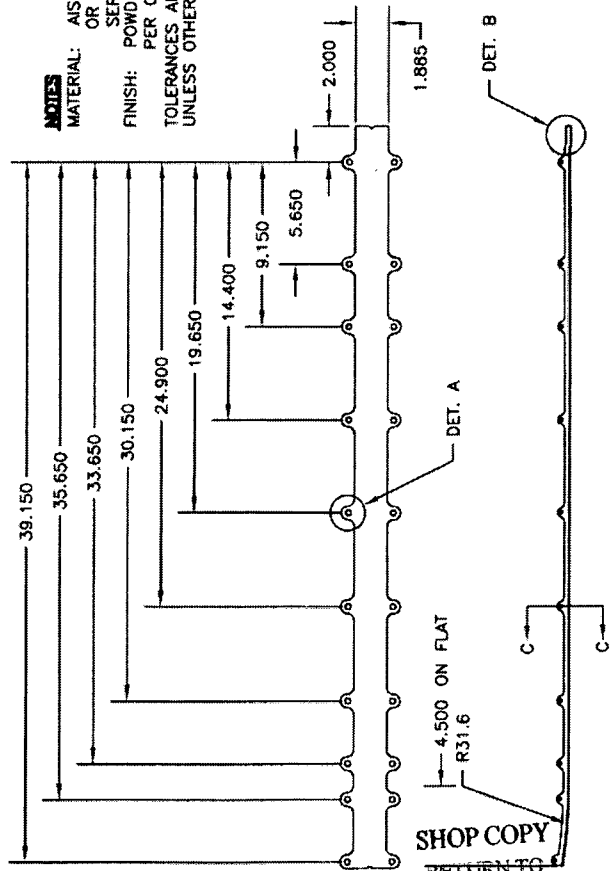
D2656-13



D2656-11



D2656-15



NOTES
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05.09.02

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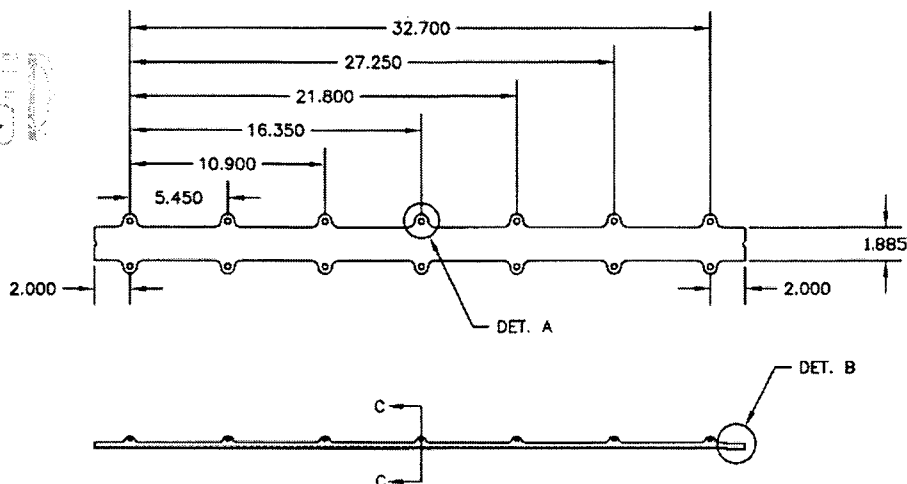
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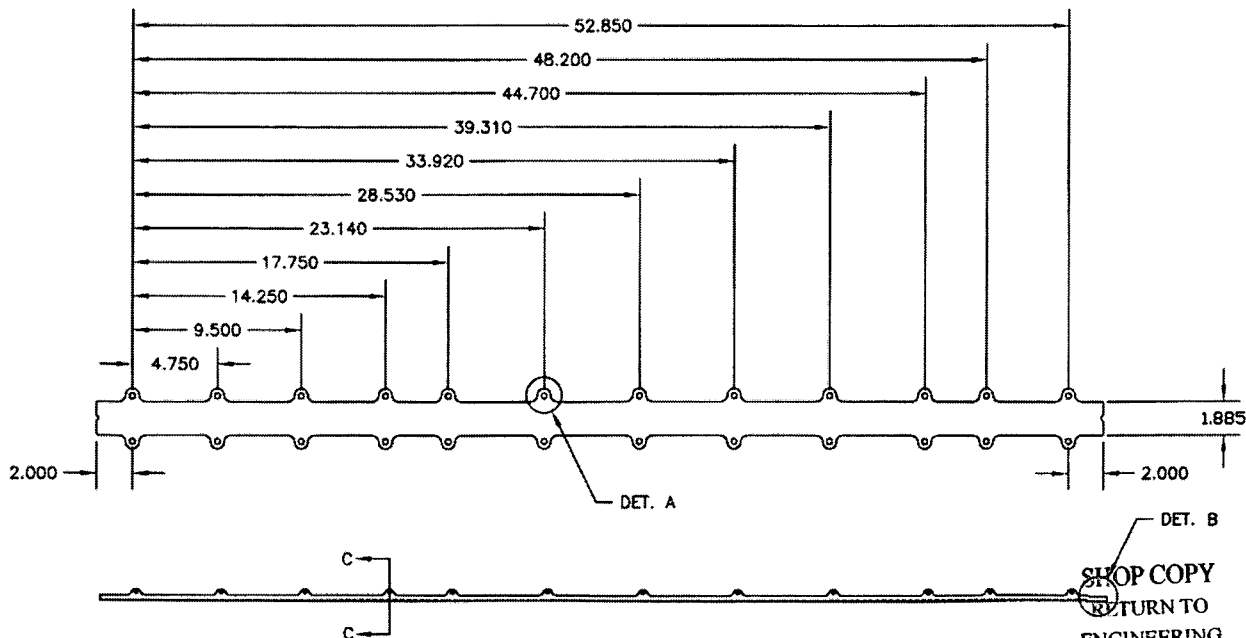
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
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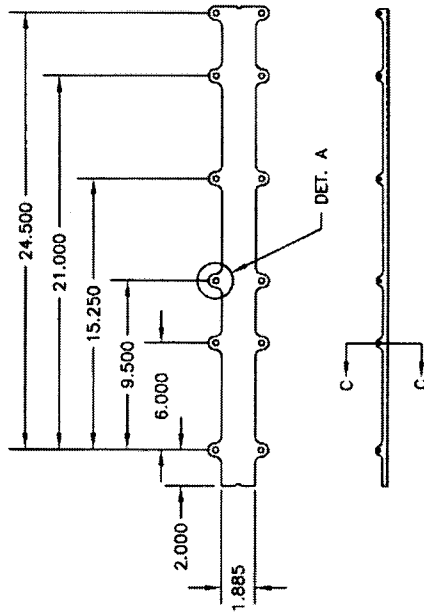
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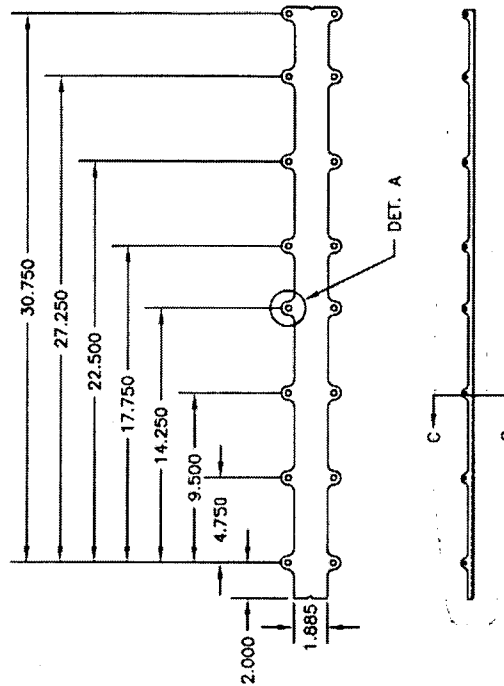


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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

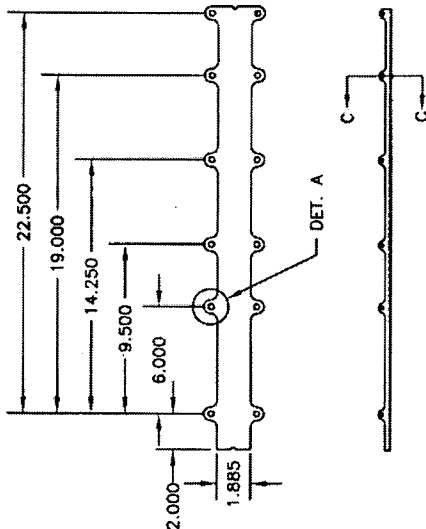
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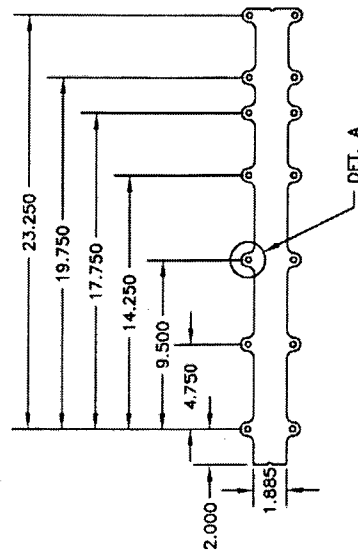
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D2656-31



D2656-35



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FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

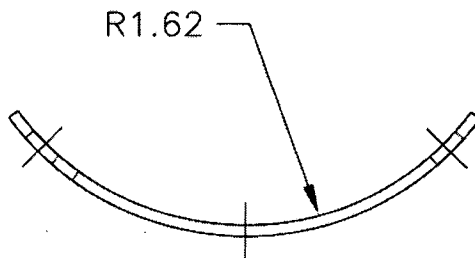
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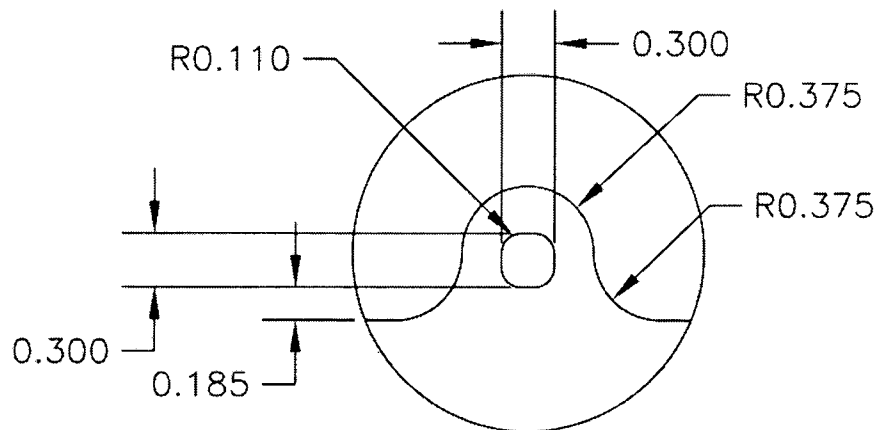
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

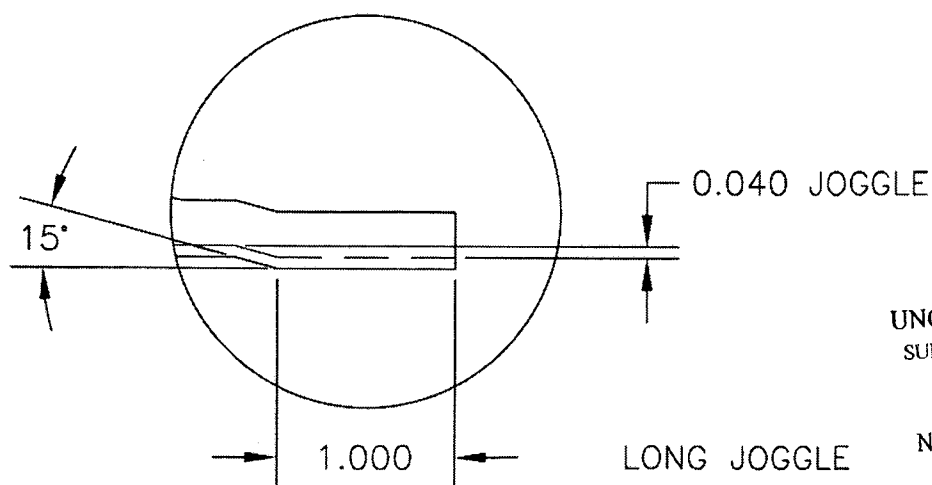


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DETAIL A



DETAIL B



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